

Work Order ID 58617

May 12, 2010 12:31:09 PM



Page 1

Item ID: D3914-1

Accept



Setup Start



Revision ID:

Item Name: Rib

Stop



Start Date: 12/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date:

10-5-12

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

A

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut tube as per dwg D3914
2- debur and remove identification markings

SAD
10-05-17

4

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. J. L. S.

4

120

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

Packaging

SAD
10-05-18

4

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | | |
| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | |
|------|------|--------------------------------|----------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Work Order ID 58617

May 12, 2010 12:31:09 PM



Page 2

Item ID: D3914-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib

Start Date: 12/05/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 18/05/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/18

MF

10-518

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Picklist Print

May 12, 2010 12:31:36 PM

Page 1

Work Order ID: 58617



Parent Item: D3914-1



Parent Item Name: Rib

Start Date: 12/05/2010

Required Date: 18/05/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 4.00

Required Qty: 4.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|---------------|----------------|--------|
| M304TS0.750W.049 | | Purchased | No | | | 100 | f | 310.2651 | 8 | | | |



304 SQ Tube .75x.75x.049W



SAD 10-05-17

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| MAT | 166.3158 | |
| 113763 | 0 | |
| 114323 | 166.3158 | |
| MAT017 | 143.9493368 | |
| 113763 | 24.25 | |
| 114298 | 119.699337 | |

7114677

25.2632

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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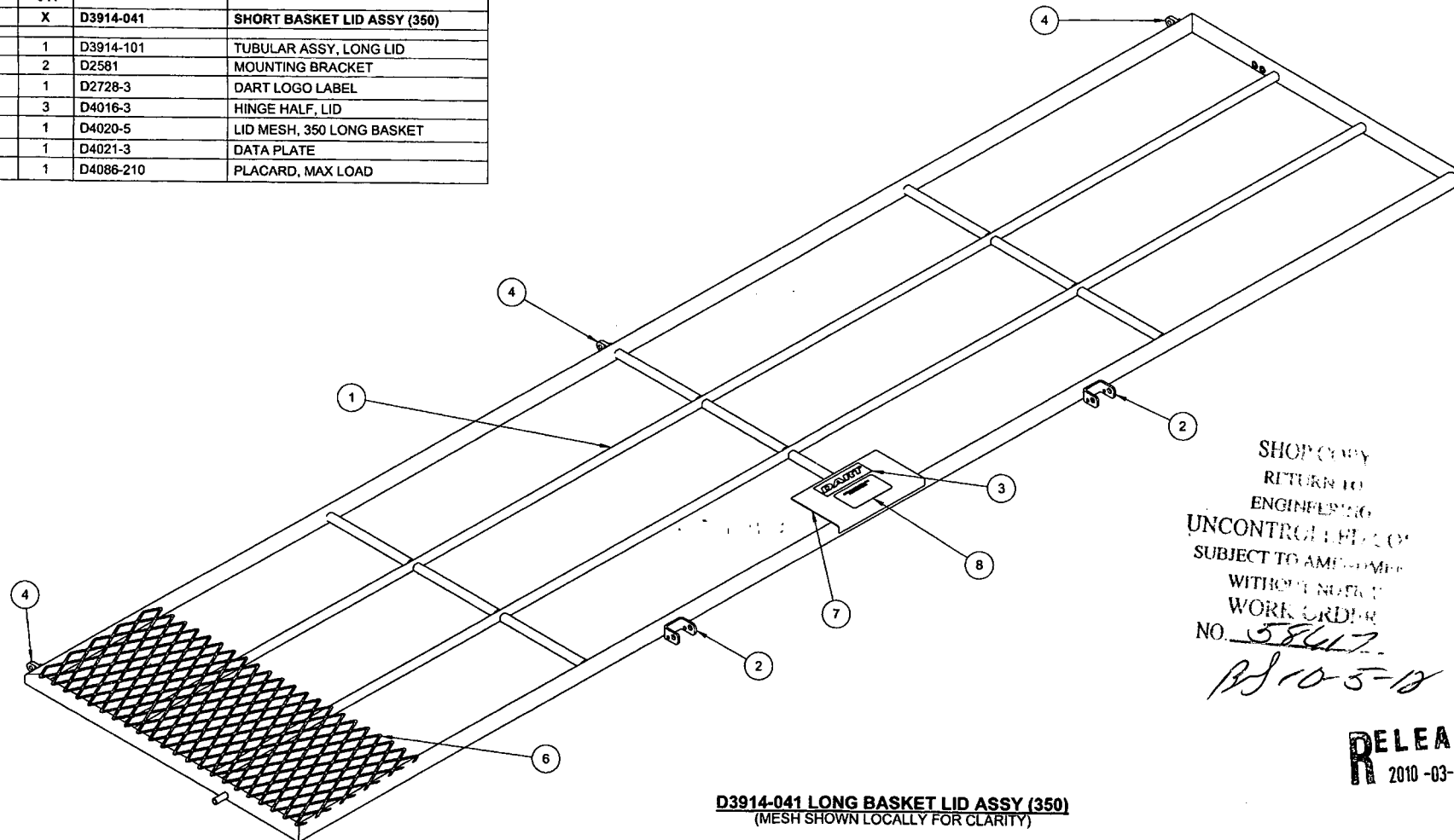
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

| ITEM | QTY | P/N | DESCRIPTION |
|------|-----|-----------|-----------------------------|
| | X | D3914-041 | SHORT BASKET LID ASSY (350) |
| 1 | 1 | D3914-101 | TUBULAR ASSY, LONG LID |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 1 | D2728-3 | DART LOGO LABEL |
| 4 | 3 | D4016-3 | HINGE HALF, LID |
| 6 | 1 | D4020-5 | LID MESH, 350 LONG BASKET |
| 7 | 1 | D4021-3 | DATA PLATE |
| 8 | 1 | D4086-210 | PLACARD, MAX LOAD |



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58617

10-5-18

RELEASED
2010-03-22

| | | | |
|---|-------------|--------|--------------|
| A NEW ISSUE | | JPH | 10.03.16 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | | |
| DRAWN | JPH | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.03.16 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | REV. A | SHEET 1 OF 4 |
| DRAWING NO. D3914 | | TITLE | SCALE |
| LONG BASKET LID ASSY (350) | | | NTS |
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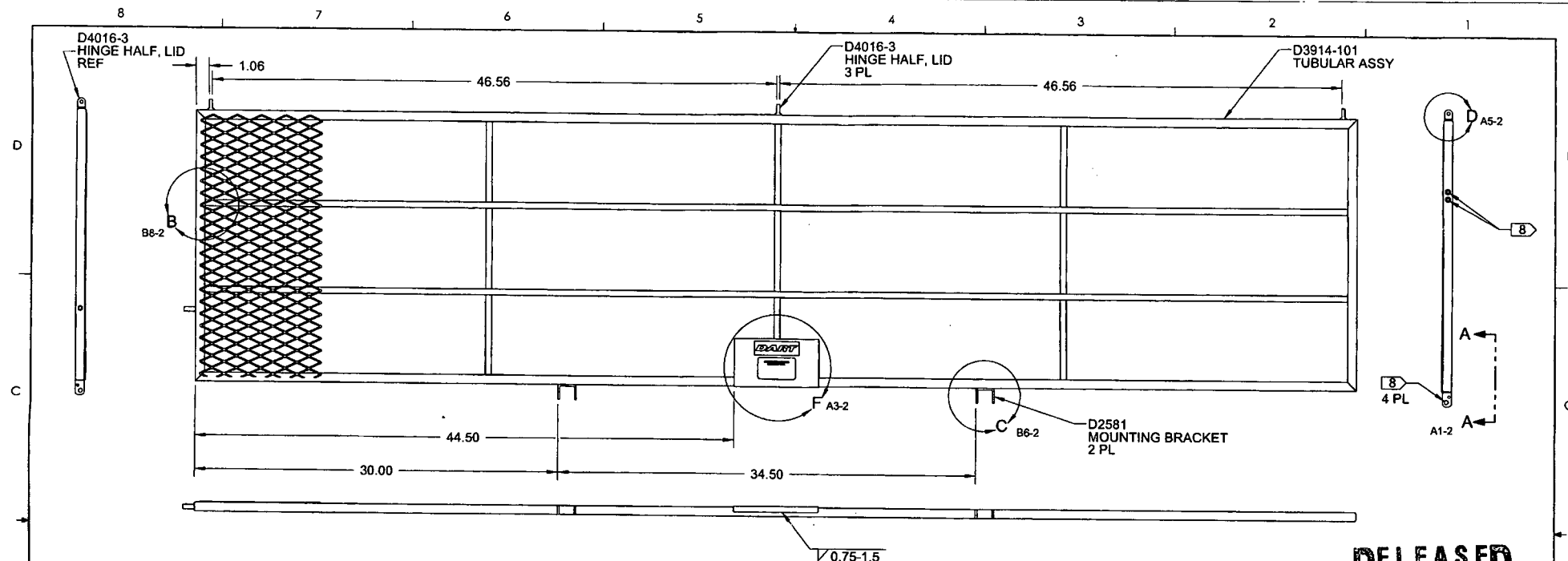
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|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

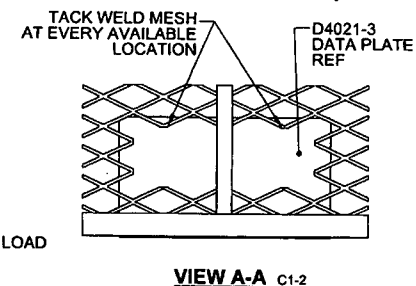
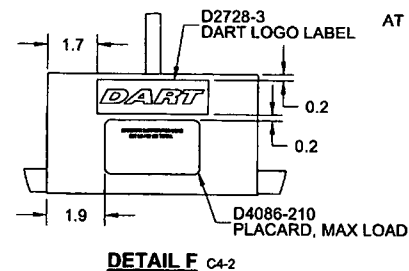
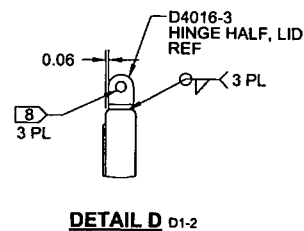
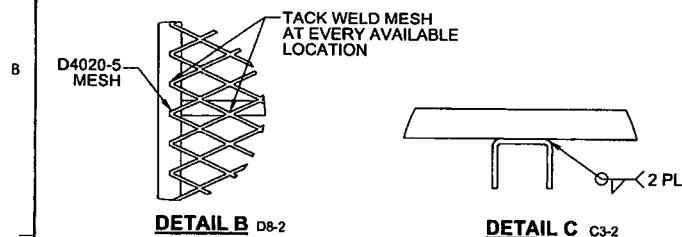
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NOTE: Date & initial all entries







D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 22.35 lbs APPROX
 - 8) MASK HOLES PRIOR TO FINISHING
 - 9) WELD PER DART QSI 004

wo 58617

| | | | |
|---|---|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED |  | DRAWING NO. | REV. A |
| MFG. APPR. |  | D3914 | SHEET 2 OF 4 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | LONG BASKET LID ASSY (350) | NTS |
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2010-03-22

| W/O: | | | WORK ORDER CHANGES | | | | | |
|------|------|--|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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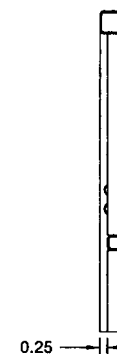
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

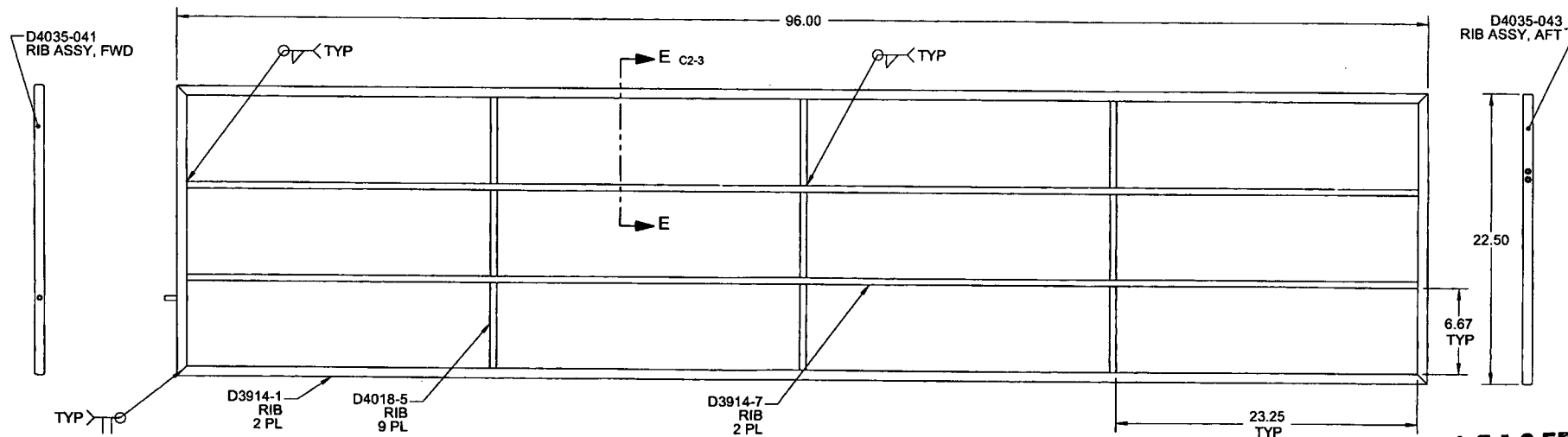
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| | | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|--------------------------------|
| | X | D3914-101 | TUBULAR ASSY, BASKET LID (350) |
| 1 | 2 | D3914-1 | RIB |
| 2 | 2 | D3914-7 | RIB |
| 3 | 9 | D4018-5 | RIB |
| 4 | 1 | D4035-041 | BASKET LID RIB ASSY, FWD |
| 5 | 1 | D4035-043 | BASKET LID RIB ASSY, AFT |



SECTION E-E CS-3



8 D3914-101 TUBULAR ASSY, LONG LID

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

WB 58617

| | | | |
|------------|----------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | | DRAWING NO. | REV. A |
| MFG. APPR. | | D3914 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | LONG BASKET LID ASSY (350) | NTS |
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2010-03-22

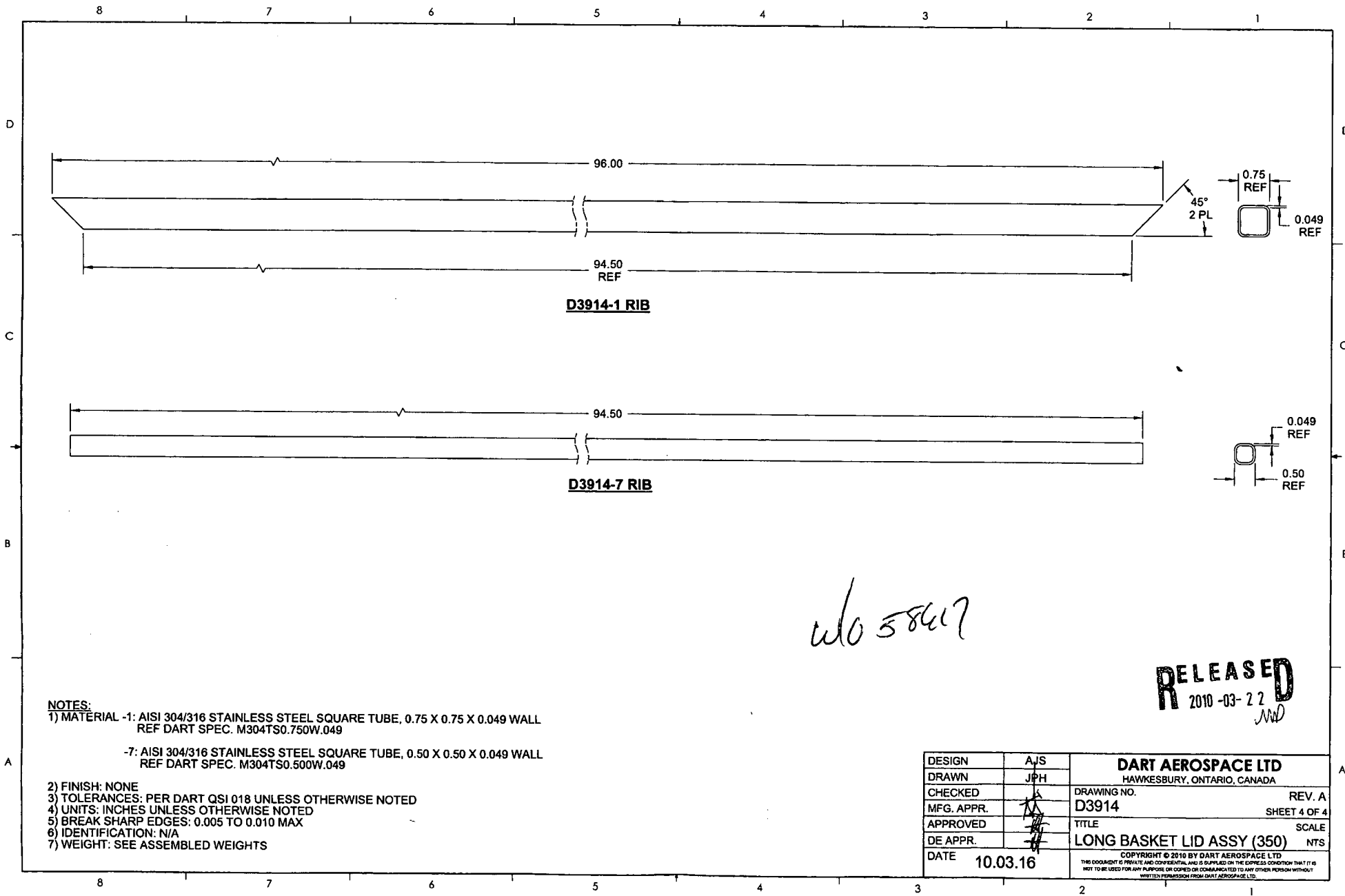
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries







NOTES:

1) MATERIAL -1: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

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2010-03-22
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| MFG. APPR. |  | D3914 | SHEET 4 OF 4 |
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